

# Jeep TJ Wrangler Tube Sleeves

Thank you for purchasing our Jeep TJ Inner Tube Sleeves!

## Installation Notes:

- Installation of the product requires a trained welder
- Refer to the factory service manual for your vehicle for removal/installation of your axle.

## Tools Required:

- Welder
- Hammer
- Drill
- ¼" Drill Bit
- ½" Drill Bit
- Grinder
- Various Hand Tools
- Factory Service Manual

### Step 1:

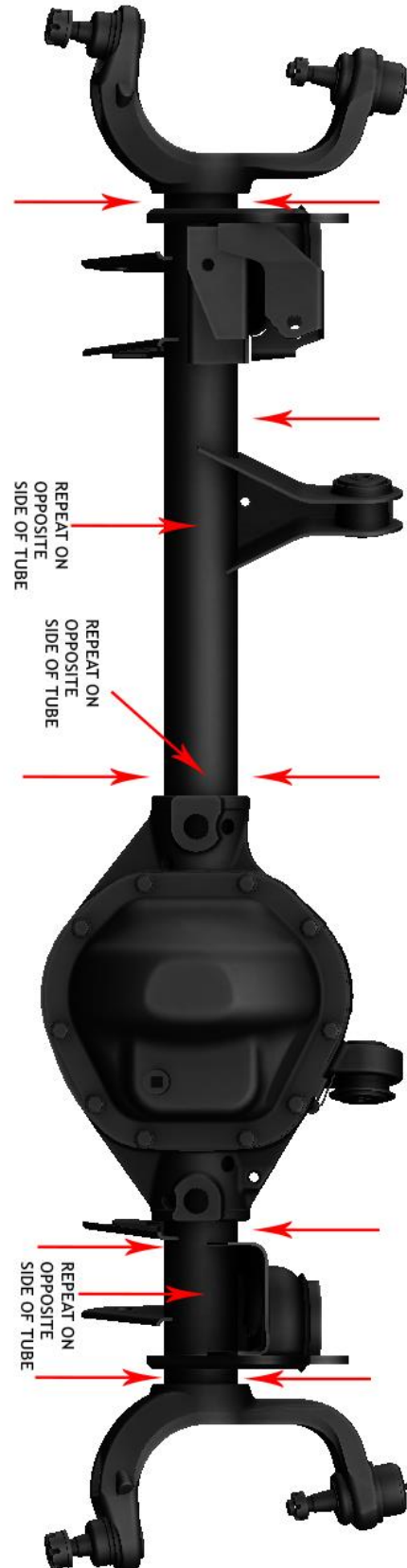
Using your factory service manual as a guide, remove the front axle from the Jeep.

### Step 2:

After the axle has been removed from the vehicle. Remove the brake calipers, unit bearings, axle shafts, knuckles, differential carrier, and inner axle seals from the housing.

### Step 3:

You are now ready to drill the holes for the plug welds in the axle tubes. The location of the holes is not critical, space them out as far as possible, but locate them so that the drilling and welding can be done easily. You will need to drill at least 6 holes in the short side of the axle tube, and at least 8 on the long side. See the image for recommended hole locations.



**Step 4:**

Once the location of the holes has been determined drill pilot holes with a 1/4" drill bit at all locations.

**Step 5:**

Using the 1/2" drill bit enlarge all pilot holes.

**Step 6:**

Remove any metal shavings from inside the axle housing. (Compressed air works well for this).

**Step 7:**

Insert the tube sleeves in each side of the axle. The sleeves should slide in the axle until they are 1/8" from the end of the tube.

**Step 9:**

After the sleeve is properly positioned in the tube fill all holes with weld.

**Step 10:**

Weld the end of the sleeves to the end of the axle tubes.



**Step 11:**

Re-assemble and re-install the axle, use the factory service manual for your Jeep to determine the proper procedures and torque specifications.

**Congratulations installation is now complete!**

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